DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-011844
Date Inspected: 07-Feb-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Li Yang and Wu Zhi Cheng

CWI Present:	☑ Yes	☐ No		**Inspected CWI report:**	☐ Yes	☑ No	☐ N/A
Rod Oven in Use:	☑ Yes	☐ No	☐ N/A	**Electrode to specification:**	☑ Yes	☐ No	☐ N/A
Weld Procedures Followed:	☑ Yes	☐ No	☐ N/A	**Qualified Welders:**	☑ Yes	☐ No	☐ N/A
Verified Joint Fit-up:	☑ Yes	☐ No	☐ N/A	**Approved Drawings:**	☑ Yes	☐ No	☐ N/A
Approved WPS:	☑ Yes	☐ No	☐ N/A				
Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A				

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 6CW to 7AW

This QA Inspector observed ZPMC welding personnel performing repair welding from inside by Flux Cored Arc Welding (FCAW) for Linear Misalignment which was found at Side Panel to Bottom Panel after Inspection. The weld joints are identified as Seg033B-001, Seg033B-009 and Seg033B-011. The welder is identified as 220066. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-3G (3F)-Repair. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 6CW to 7AW

This QA Inspector observed ZPMC welding personnel performing repair welding from External side by Shielded Metal Arc Welding (SMAW) for Linear Misalignment which was found at Side Panel to Bottom Panel after Inspection. The weld joints are identified as Seg033A-004. The welder is identified as 037932. In process SMAW

appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-FCM-Repair-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Corner Assembly Counter Weight side for Transverse Splice Weld. The weld joints are identified as OBW7C -006. The welder is identified as 068917. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Corner Assembly Cross Beam Side for Transverse Splice Weld. The weld joints are identified as OBW7C -010. The welder is identified as 069683. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Counter Weight side for Transverse Splice Weld. The weld joints are identified as OBW7C -007. The welder is identified as 068917. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Cross Beam Side for Transverse Splice Weld. The weld joints are identified as OBW7C -009. The welder is identified as 069683. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Bottom Panel for Transverse Splice Weld. The weld joints are identified as OBW7C -008. The welder is identified as 069683. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC personnel's at Segment 7BW to 7CW between Panel Point (PP) 52 and PP 53 Bottom Panel, Side Panel (Cross Beam and Counter Weight side) welding is in progress for Transverse Splice.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel's Segment 6CW to 7AW between PP 47 and PP 48 Side Panel to Bottom misaligned area against B-WR 10059 welding is in progress.

6CW

This QA Inspector observed ZPMC personnel's counter weight side Suspender Bracket installation is in progress.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer